Qty:

Date:

Tuesday, 12/12/2006 10:28:57 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 29883

Job Number **Estimate Number**

: 10104

P.O. Number

: N/A

This Issue

Prsht Rev. First Issue

Previous Run

: NC

: MA : 27522

: 12/12/2006

S.O. No. : N/A

: SMALL /MED FAB Type

Drawing Name

: CLEVIS

Part Number

: D2012107

Drawing Number

D2012-107 REV. C

Project Number **Drawing Revision**

: N/A : C

Material **Due Date** NIA:

: 1/15/2007

40 Um:

Each

Written By

Comment

Checked & Approved By

: Est: D

Re-format, Drawing to Rev. C SM

Est Rev:E Now on Waterjet 06-06-13 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

304/316 .063 Sheet



Comment: Qty.:

0.0146 sf(s)/Unit Total:

0.5838 sf(s)

304/316 .063 Sheet

(M304S063)

Batch: <u>MIDI 873</u>

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2012-107

Prog Rev:_

40

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



. Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE





Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107



40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			· L.			1					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>07/0//37</u>
	•		QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification	Approval	A			
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	Approval QC Inspector			
						İ					
							i				
					<u> </u>						
								41			

NOTE: Date & initial all entries

Tuesday, 12/12/2006 10:28:58 AM Date: User: Kim Johnston **Process Sheet Drawing Name: CLEVIS** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29883 Part Number: D2012107 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 6.0 (40) Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57 QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE U 07.01.30 Job Completion

Dart Aerospace Ltd

D a	oopaoo Eta								
W/O:		<u>.</u>	WORK ORDER	CHANGES					
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
Part No	:	PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _	·····
					QA:	N/C Close	d:	_ Date: _	
		***************************************	MODE ODDED NON CO	NEODMANO		DV			

	Description of NC		Corrective Action Section B		Varification	Annroyal	Annroyal			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
							-			
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		·								
							-			
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Initial Chief Eng Chief Eng Chief Eng Corrective Action Section B Sign & Date	STEP Section A Initial Chief Eng Action Description Chief Eng Section C Section C	STEP Description of NC Corrective Action Section B Verification Section C Chief Eng Chi			

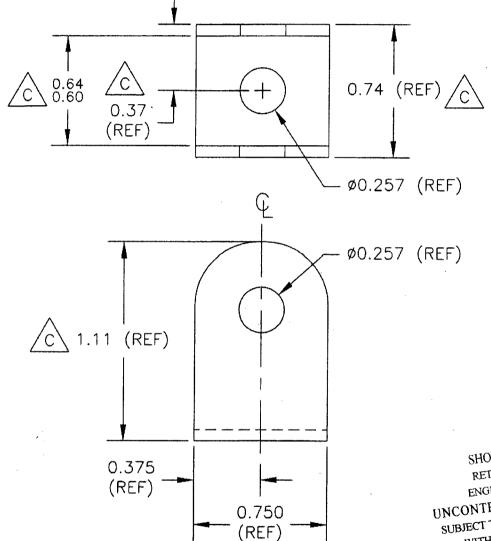
NOTE: Date & initial all entries





DESIG ,	N BW	ORAWN BY		AEROSPACE KESBURY, ONTARIO, CANAI		<u> </u>
CHEC	(ED)	APPROVED	DRAWING NO.		RE	v. c
	TO	1 et	D2012-107		SHEET 1 C)F 2
DATE	- /		TITLE		SC	CALE
99.1	2.20		CLEVIS			2:1
Α		94.10.27	NEW ISSUE			

99.12	2.20	CLEVIS 2:1
Α	94.10.27	NEW ISSUE
В	99.04.30	ADD FLAT PATTERN
С	99.12.20	0.74 WAS 0.680



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

MATERIAL: AISI 304/316 SS 0.063 THICK

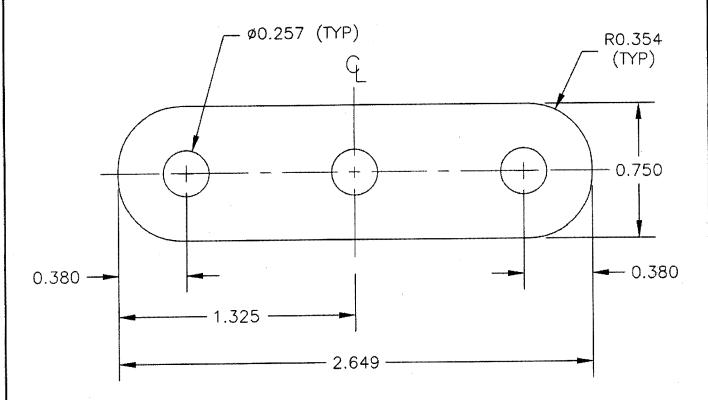
USE 0.032 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES



DESIGN BW	ORAWN BY	DART AERO HAWKESBURY, O	SPACE LTD INTARIO, CANADA
CHECKED	APPROVED A	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE.		TITLE	SCALE
99.12.20		CLEVIS	2:1





D2012-107 FLAT PATTERN

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: AISI 304/316 SS 0.063 THICK TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order: 29 833
Description: CLENIS	Part Number: 1020/2-107
Inspection Dwg: Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype									
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
0, 380	1/- 0.010	0.381		44 17 1	Vern	• •			
1.325	+/-0.010	1,322			Vern				
2.649	1-0.010	2.651			Vern				
0.380	1/- 0.010	0.380			ten				
0.750	1-0.010	0.756			vern				
RO. 354	4/-0.010	10.354			R-6				
Ø0.257_	40.006	\$0.239			Vern				
Carried 8									
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Measured by:	SAN	Audited by:		Prototype Approval:	
Date:	CE!12:30	Date:	67-01-02	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue .	KJ/JLM	



